

Patent Claims

1. A method for producing a wiper arm, especially for window wiping systems in vehicles, comprising a wiper arm fixing part (10) and a wiper arm articulated part (14), characterized in that the wiper arm articulated part (14) is stamped out of a sheet metal material which is precoated on one side, and then is bent in such a way that the coated surface is placed on the inside, in that the wiper arm fixing part (10) is joined to the wiper arm articulated part (14) by means of a hinge pin, and in that the wiper arm is then provided with a layer of paint by means of a spraying or powder technique.
2. The method as claimed in claim 1, characterized in that the wiper arm articulated part (14) is produced from a precoated sheet metal material having a thickness of approximately 1.2 to approximately 2 mm.
3. The method as claimed in claim 1 or 2, characterized in that the wiper arm articulated part (14) is bent so that it has a cross section in the form of a U-shaped channel.
4. The method as claimed in any of claims 1 to 3, characterized in that a coil coating material is used as the sheet metal material which is precoated on one side.
5. The method as claimed in any of claims 1 to 4, characterized in that the wiper arm fixing part (10) is designed as a die-cast metal part.
6. The method as claimed in claim 5, characterized in that the wiper arm fixing part (10) is designed with a bearing bushing (20) for the passage of the bearing pin (18).
7. The method as claimed in any of claims 2 to 6, characterized in that the bearing pin (18) projects through the parallel legs (14a, 14b) of the

wiper arm articulated part (14) and is designed as a rivet with a rivet head (18a) at one end and a clinched area (18b) at the other axial end.

8. A wiper arm with a flat wiper blade, comprising a wiper arm fixing part and a wiper arm articulated part which is joined to the latter by a hinge pin, said wiper arm articulated part having a cross section in the form of a U-shaped channel, characterized in that the wiper arm articulated part is made from a sheet metal material which is precoated on one side and has a thickness of approximately 1.2 to approximately 2 mm, and the coated surface is arranged on the inside.